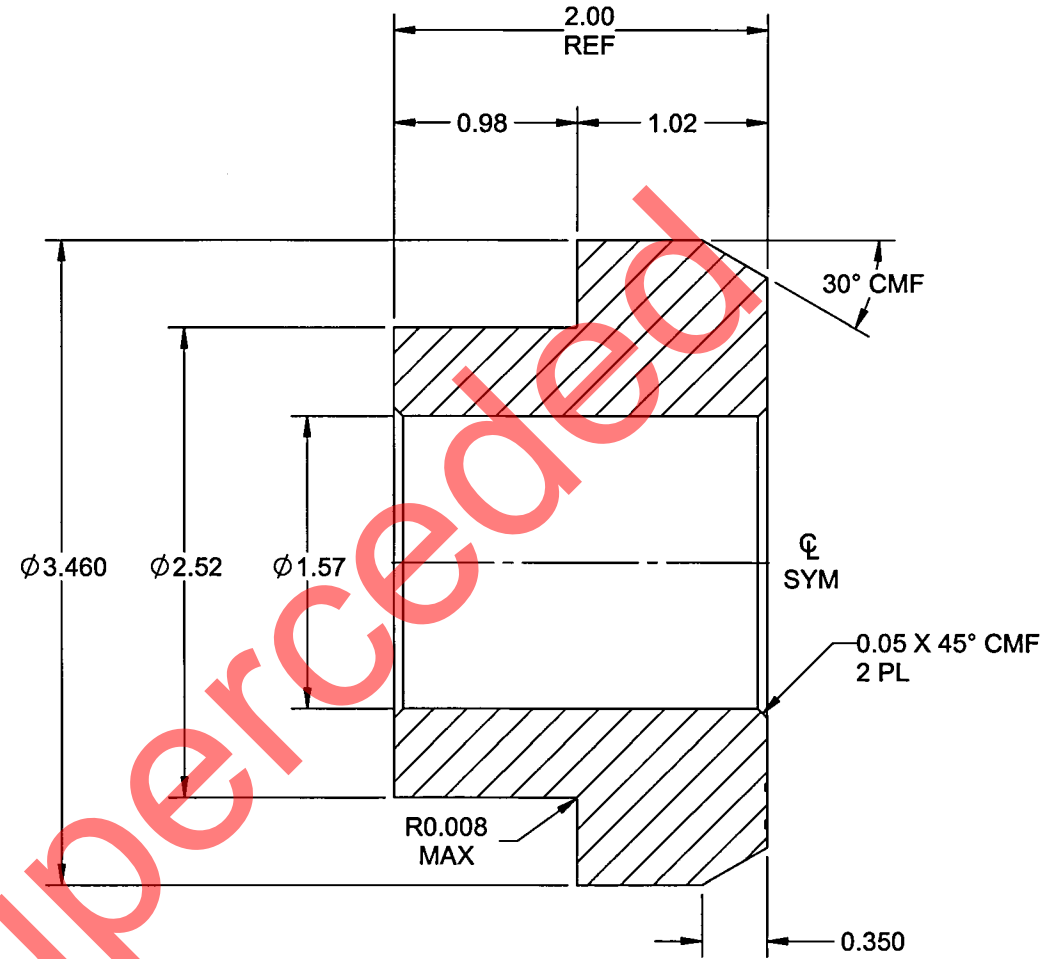
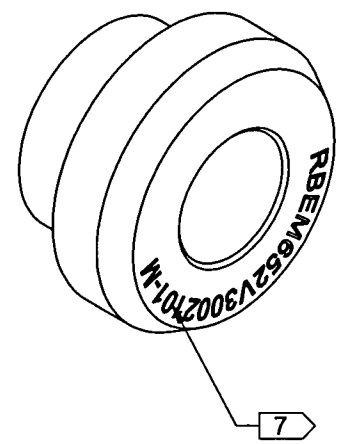
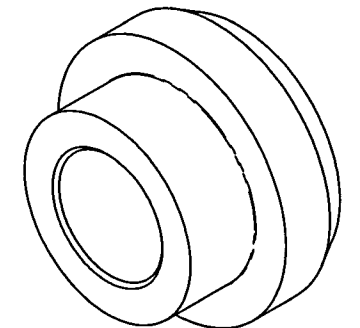


RBEM652V3002101-M-5 BASE

8



SECTION B-B



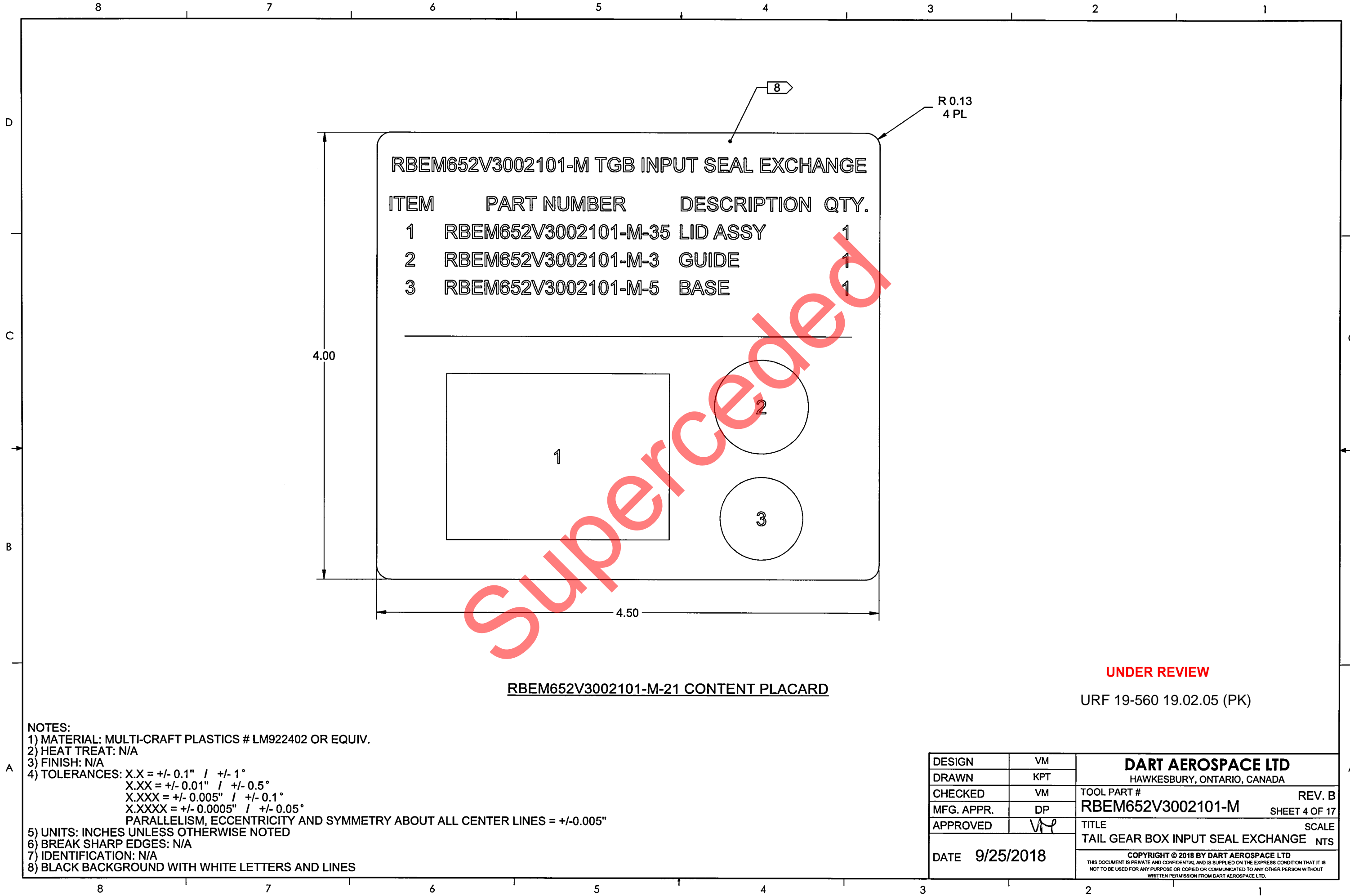
7

UNDER REVIEW

URF 19-560 19.02.05 (PK)

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN
 - 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

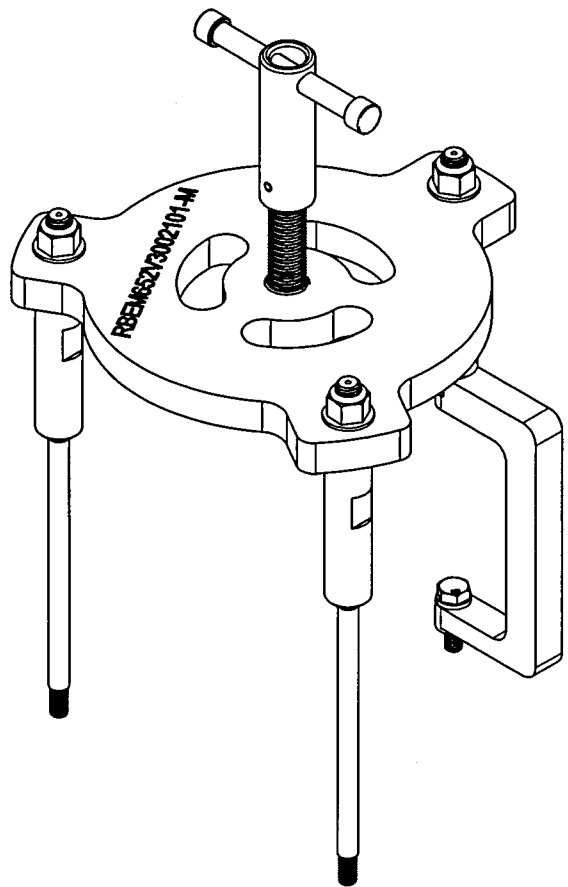
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBEM652V3002101-M	SHEET 3 OF 17
APPROVED	VM	TITLE	SCALE
DATE 9/25/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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NOTES:
1) MATERIAL: MULTI-CRAFT PLASTICS # LM922402 OR EQUIV.
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) BLACK BACKGROUND WITH WHITE LETTERS AND LINES

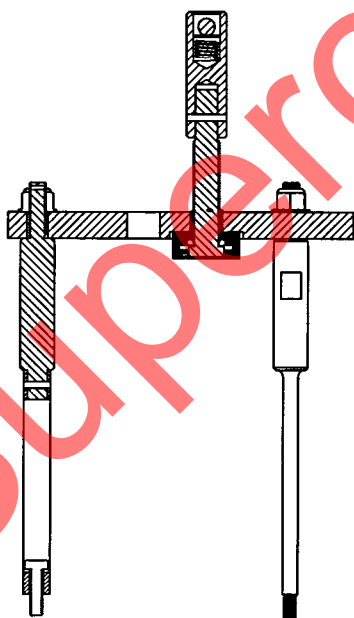
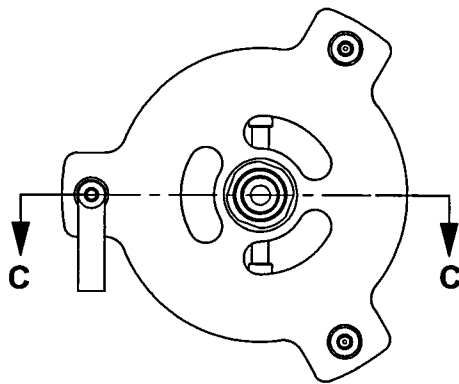
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBEM652V3002101-M	SHEET 4 OF 17
APPROVED	VM	TITLE	SCALE
DATE 9/25/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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ITEM #	QTY	PART #	PART TITLE
-7	2	RBEM652V3002101-M-7	STUD
-9	1	RBEM652V3002101-M-9	BAR HANDLE NUT
-27	1	RBEM652V3002101-M-27	STUD
-31	1	RBEM652V3002101-M-31	CAP
-39	1	RBEM652V3002101-M-39	PLATE ASSY
-41	1	RBEM652V3002101-M-41	FOOT ASSY
48	3	McMaster#99908A102 OR EQUIV	FLANGE LOCKNUT STEEL M8 x 1.25mm CLASS 10
49	1	McMaster#98380A473 OR EQUIV	DOWEL PIN STEEL 1/8" DIA. x 3/4" LG.

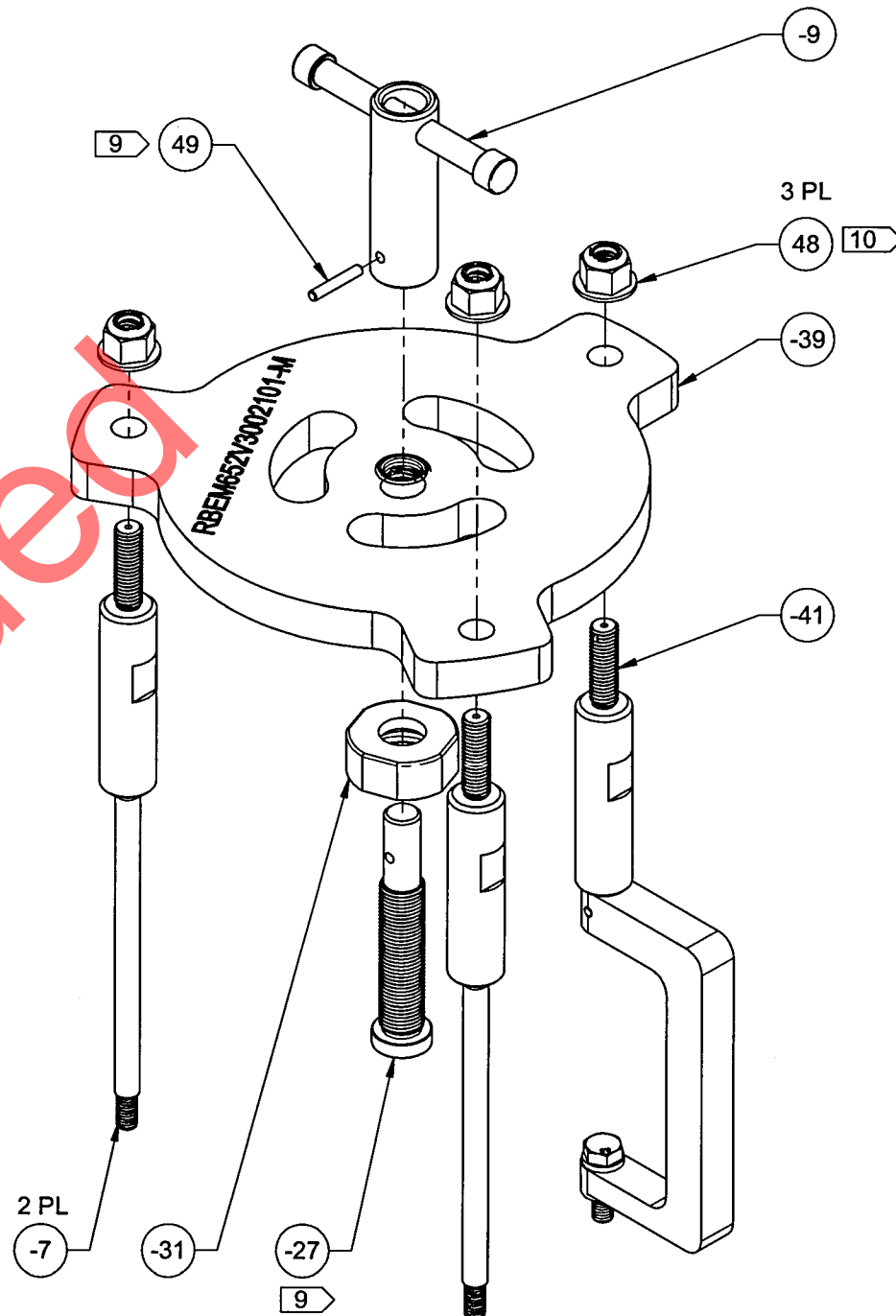


RBEM652V3002101-M-35 LID ASSY

11



SECTION C-C



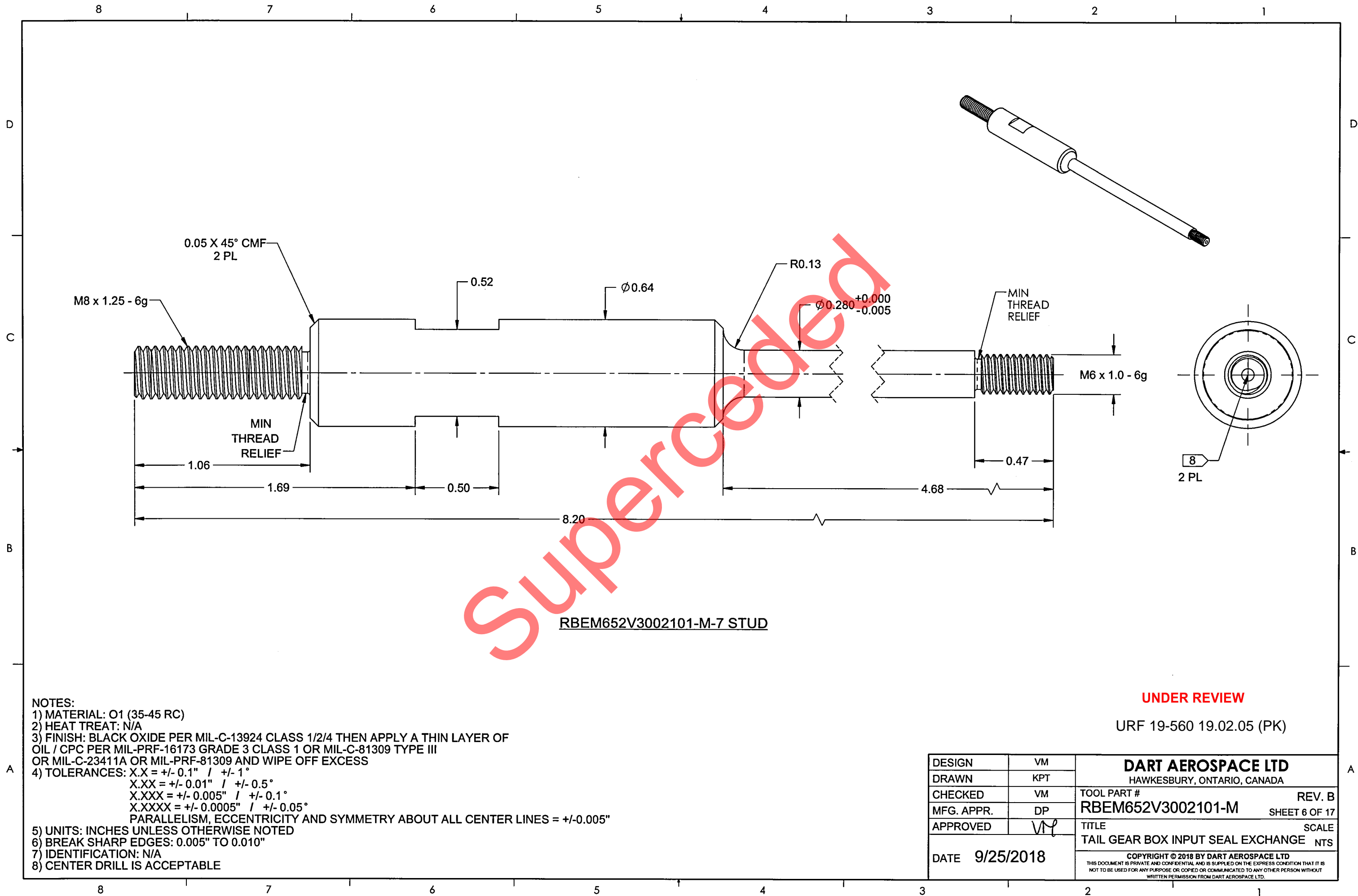
UNDER REVIEW

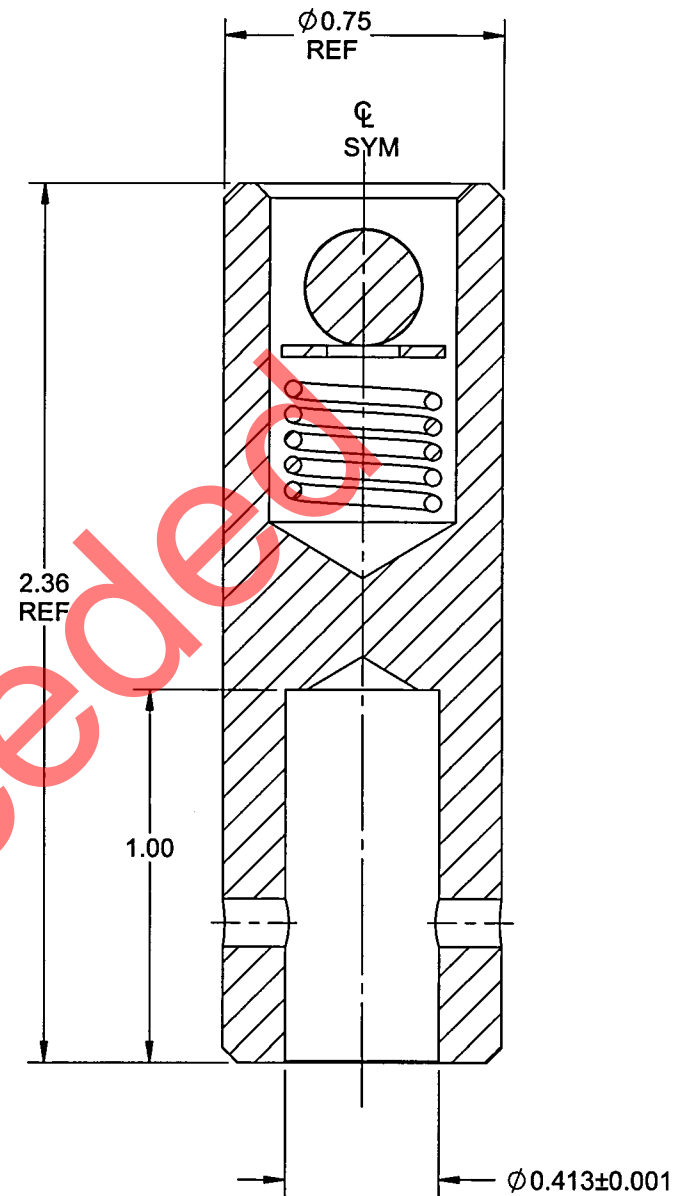
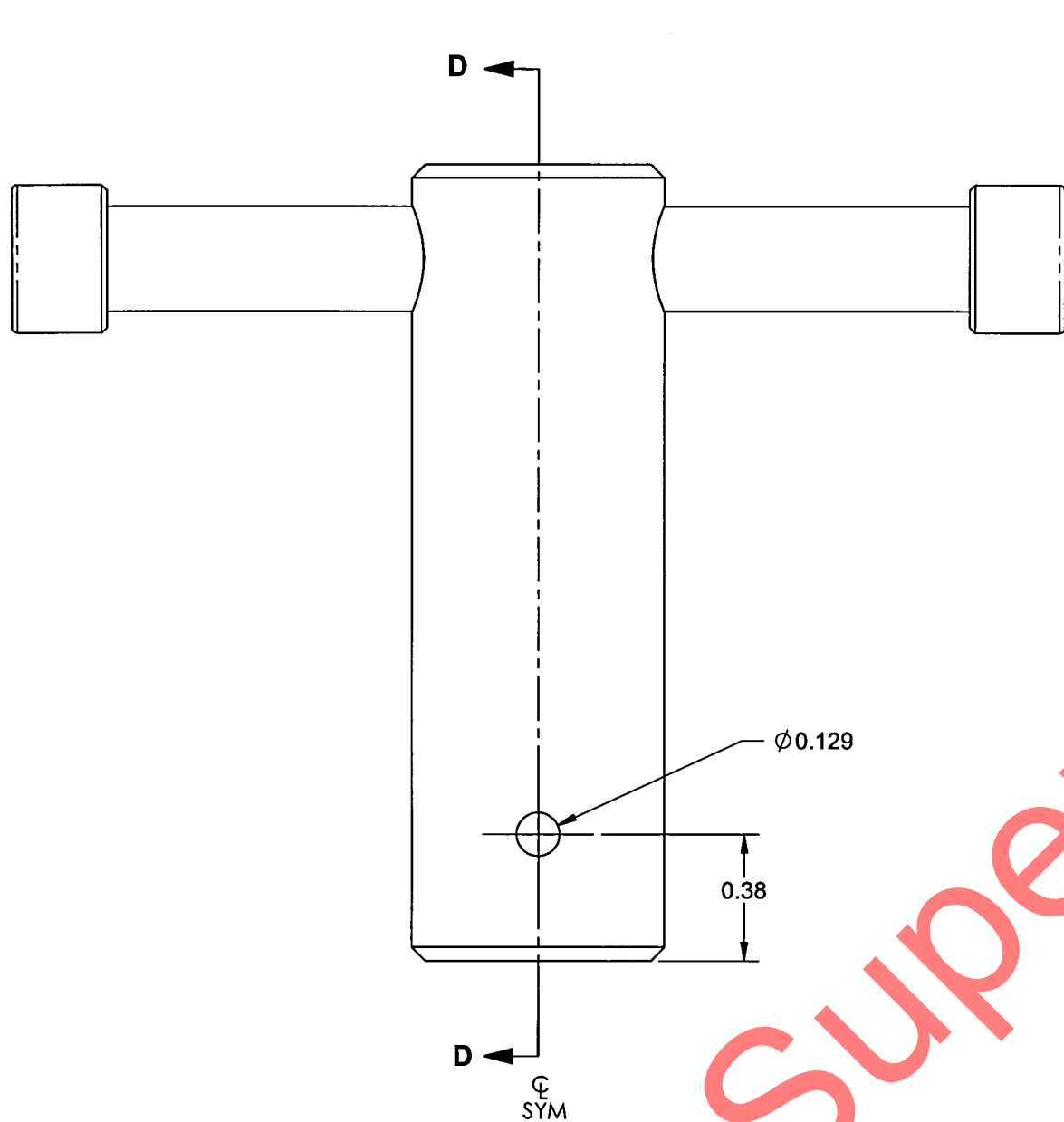
URF 19-560 19.02.05 (PK)

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 49 WITH ITEM -27 AND REMOVE EXCESS
- 10) ASSEMBLE ITEMS 48 WITH ITEMS -7 AND ITEM -41 HANDTIGHT
- 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBEM652V3002101-M	SHEET 5 OF 17
APPROVED		TITLE	SCALE
DATE 9/25/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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SECTION D-D

RBEM652V3002101-M-9 BAR HANDLE NUT

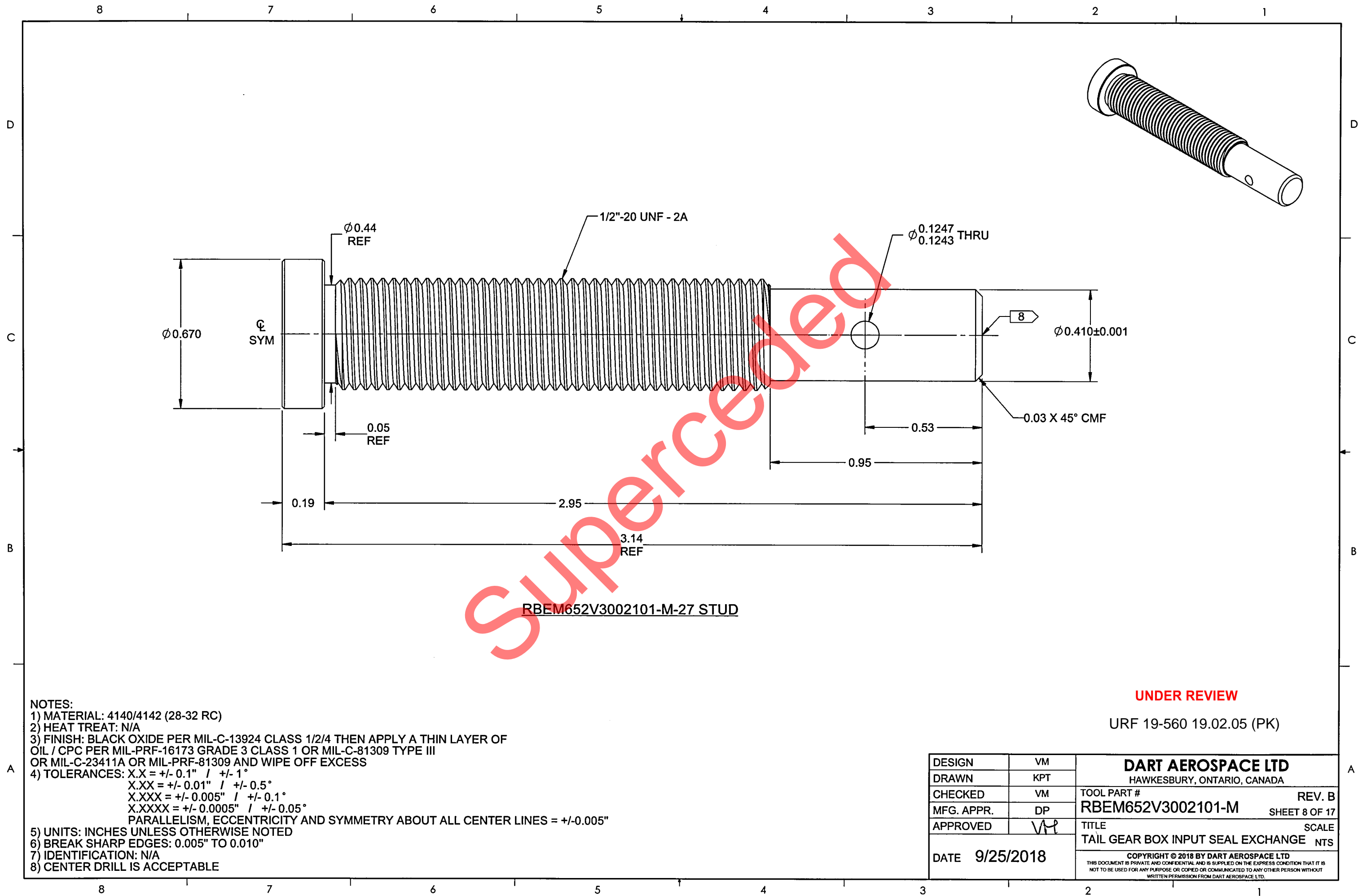
UNDER REVIEW

URF 19-560 19.02.05 (PK)

NOTES:

- 1) MATERIAL: CARR-LANE#CLM-10-BHN OR EQUIV.
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1/2/4 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBEM652V3002101-M	SHEET 7 OF 17
APPROVED	W	TITLE	SCALE
DATE 9/25/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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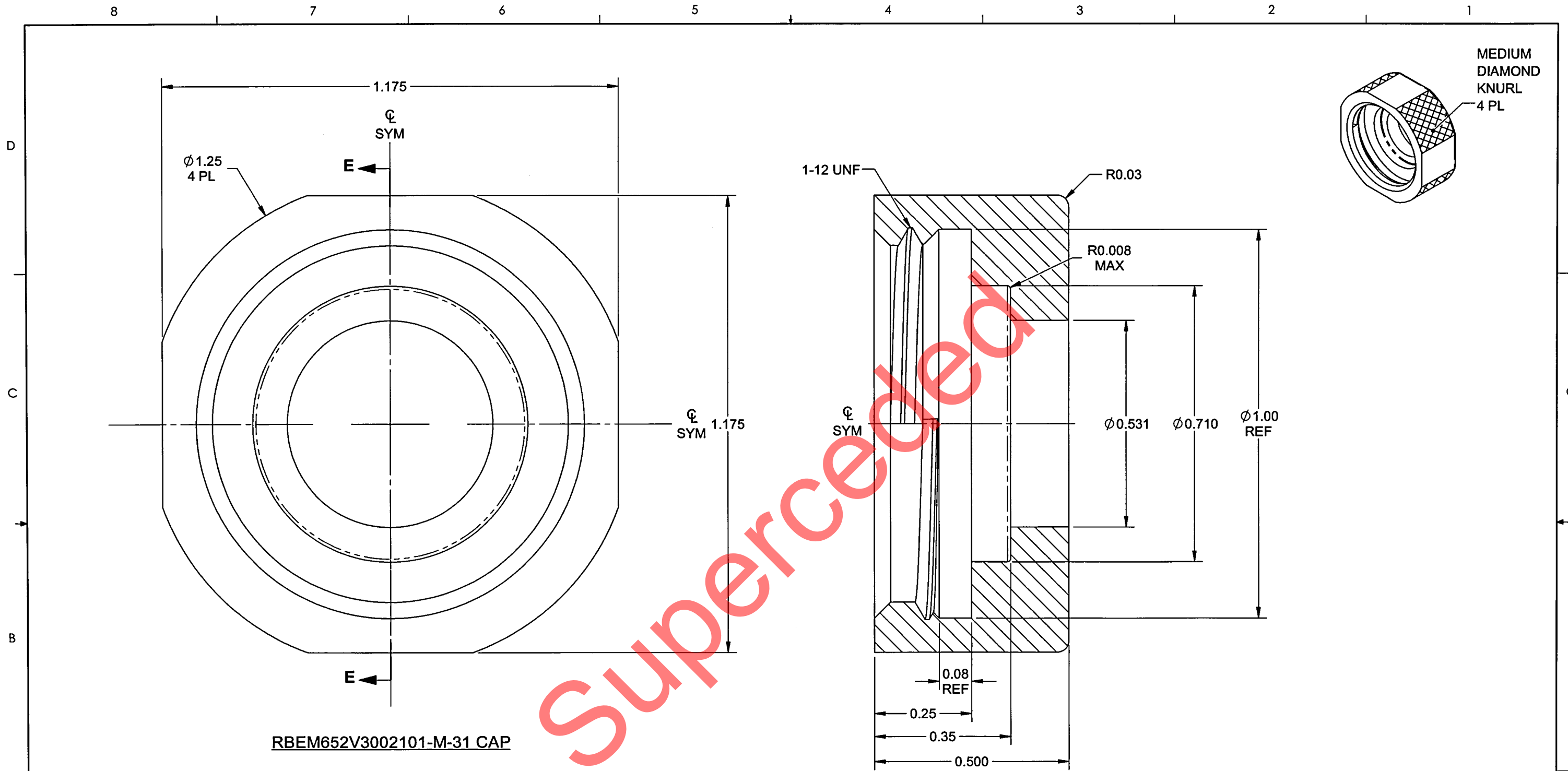
NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1/2/4 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = ± 0.1 " / $\pm 1^\circ$
X.XX = ± 0.01 " / $\pm 0.5^\circ$
X.XXX = ± 0.005 " / $\pm 0.1^\circ$
X.XXXX = ± 0.0005 " / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

UNDER REVIEW

URF 19-560 19.02.05 (PK)

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBEM652V3002101-M	SHEET 8 OF 17
APPROVED	VM	TITLE	SCALE
DATE 9/25/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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RBEM652V3002101-M-31 CAP

SECTION E-E

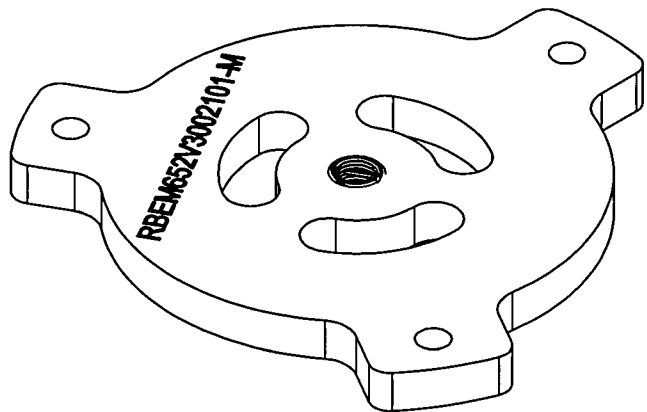
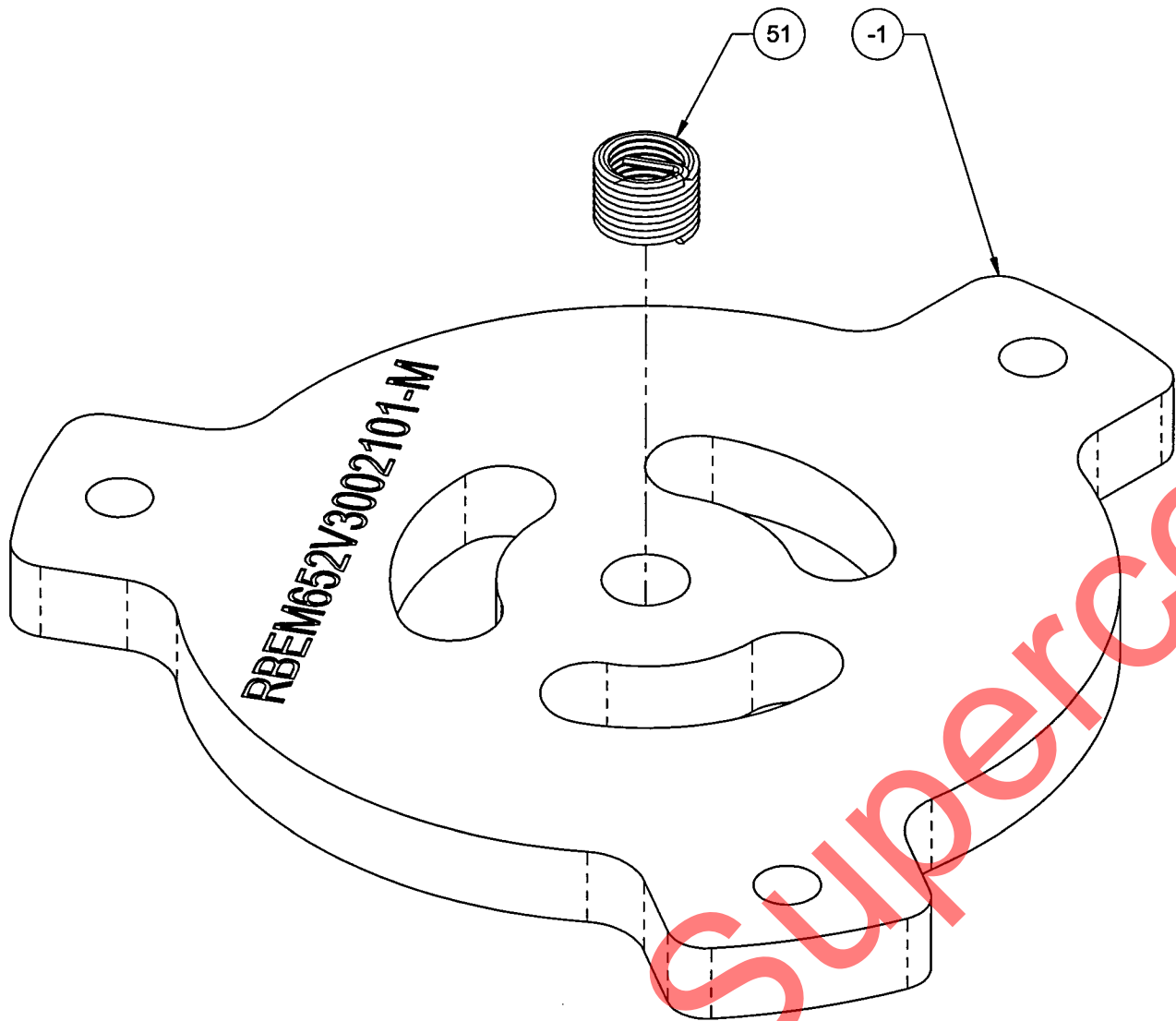
UNDER REVIEW

URF 19-560 19.02.05 (PK)

NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1/2/4 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBEM652V3002101-M	SHEET 9 OF 17
APPROVED	W	TITLE	SCALE
DATE 9/25/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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ITEM #	QTY	PART #	PART TITLE
-1	1	RBEM652V3002101-M-1	PLATE
51	1	McMaster#91732A533 OR EQUIV	HELICAL INSERT STEEL 1/2"-20 x 1/2" LG.



RBEM652V3002101-M-39 PLATE ASSY

UNDER REVIEW

URF 19-560 19.02.05 (PK)

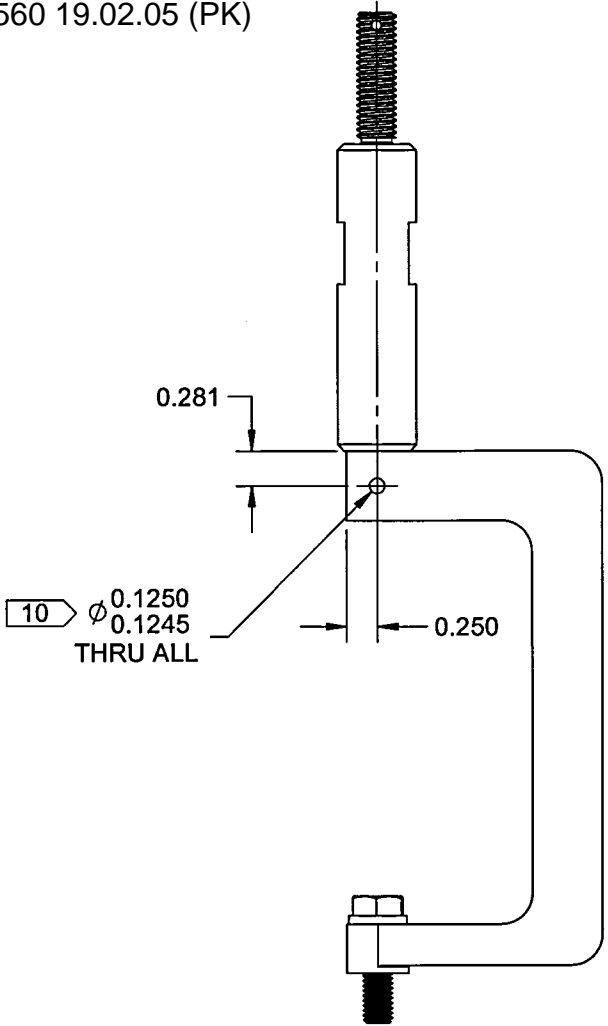
NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBEM652V3002101	SHEET 10 OF 17
APPROVED	VM	TITLE	SCALE
DATE 9/25/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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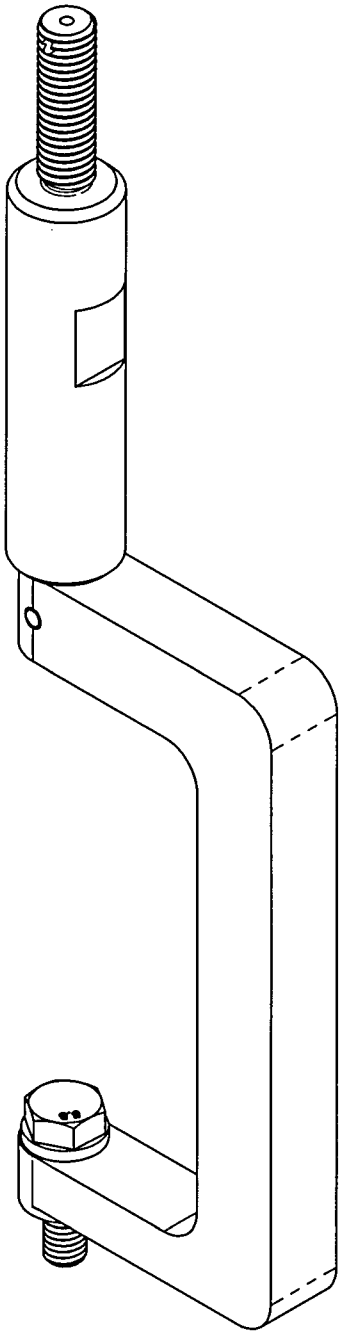
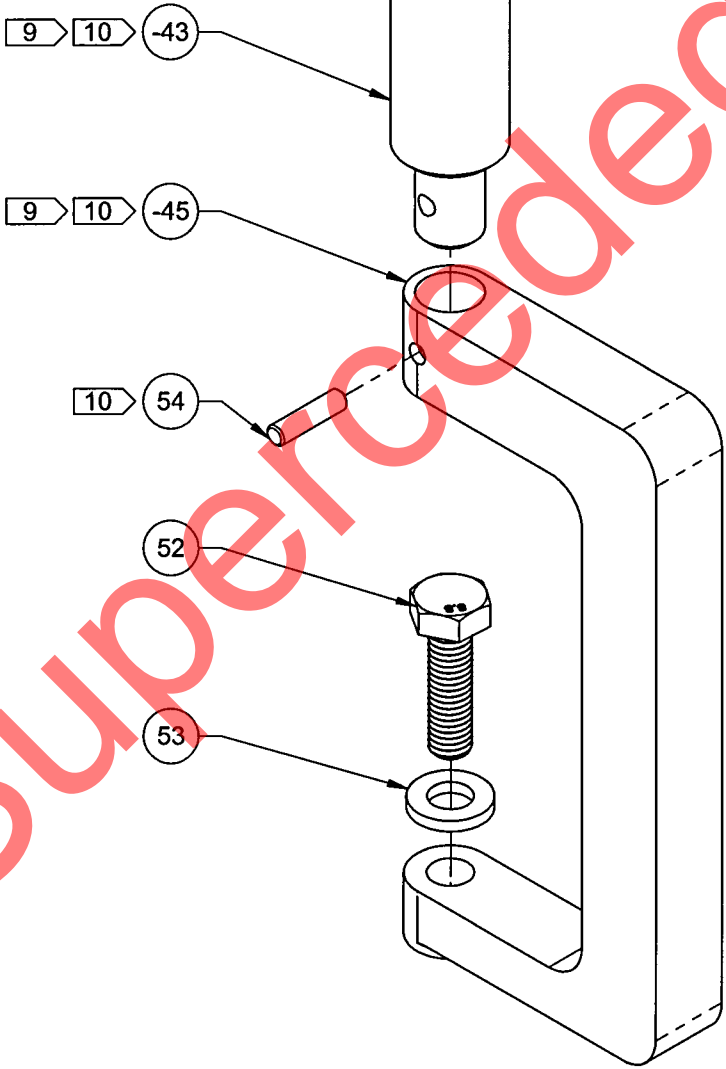
ITEM #	QTY	PART #	PART TITLE
-43	1	RBEM652V3002101-M-43	STUD
-45	1	RBEM652V3002101-M-45	STUD EXTENSION
52	1	McMaster#91280A332 OR EQUIV	STEEL HEX HEAD BOLT M6 x 1 x 22mm LG.
53	1	McMaster#91166A250 OR EQUIV	STEEL FLAT WASHER M6
54	1	McMaster#98381A471 OR EQUIV	STEEL DOWEL PIN 1/8" DIA. x 1/2" LG.

UNDER REVIEW

URF 19-560 19.02.05 (PK)



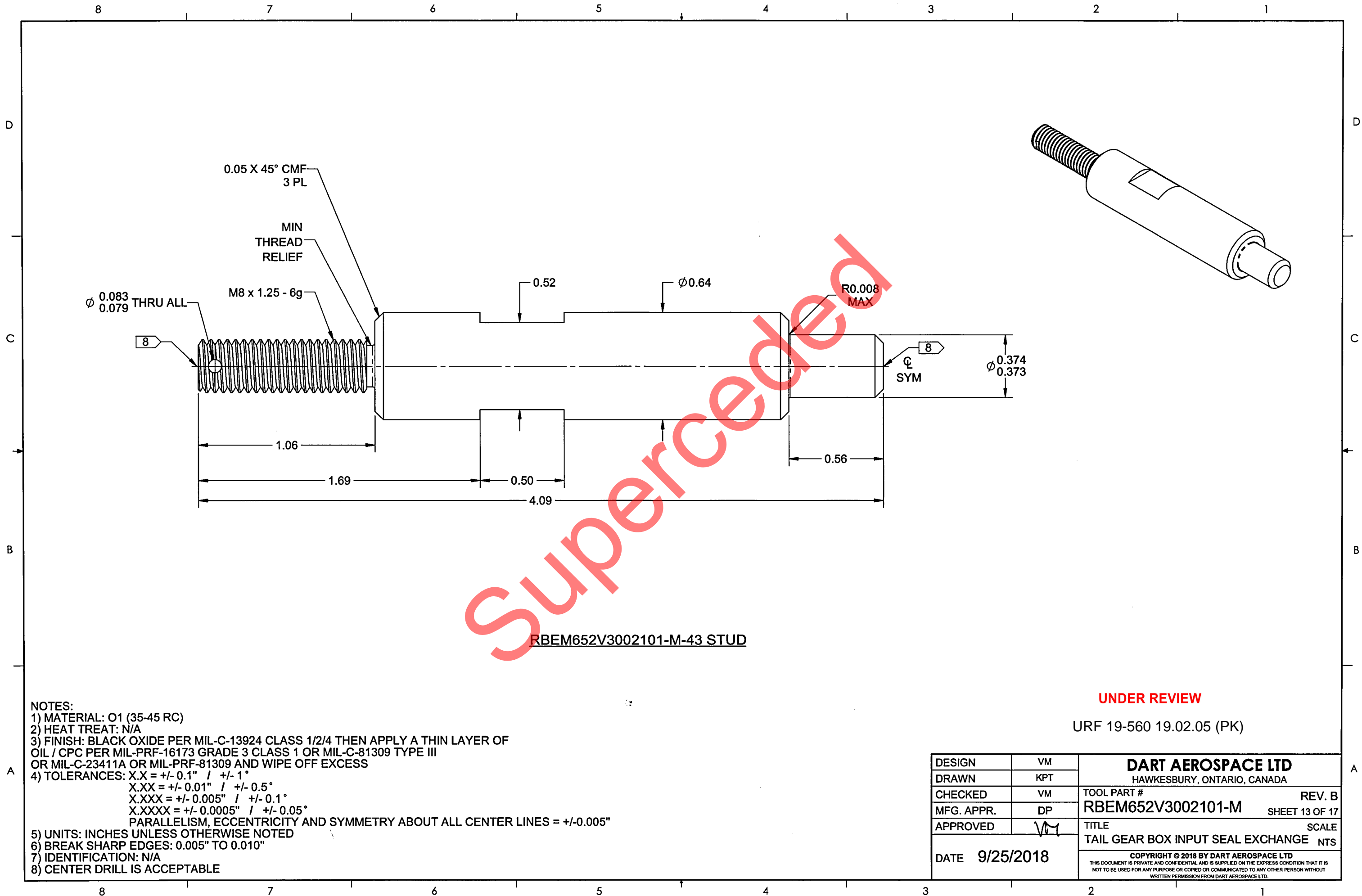
DOWEL PIN REMOVED FOR CLARITY

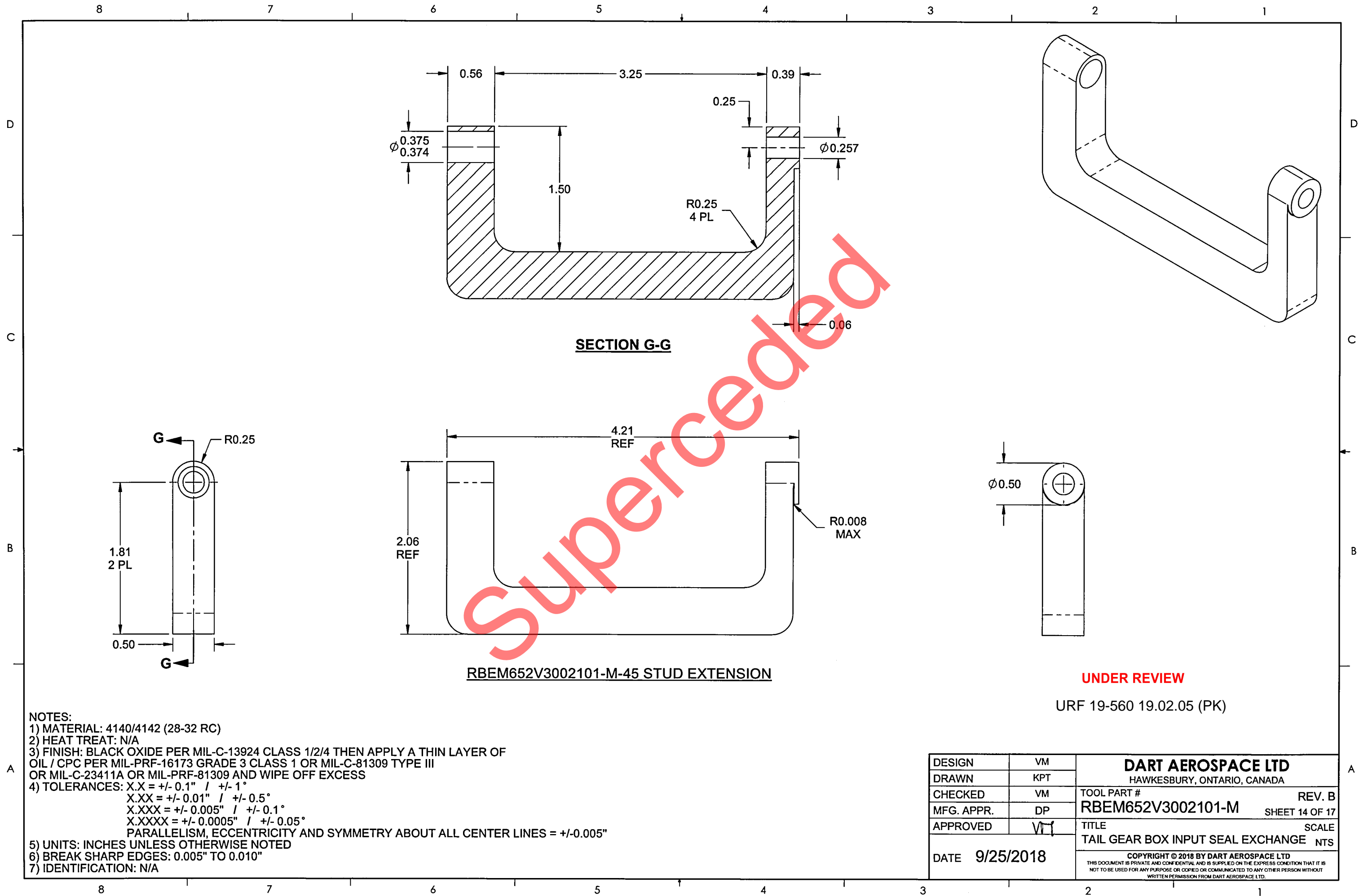


RBEM652V3002101-M-41 FOOT ASSY

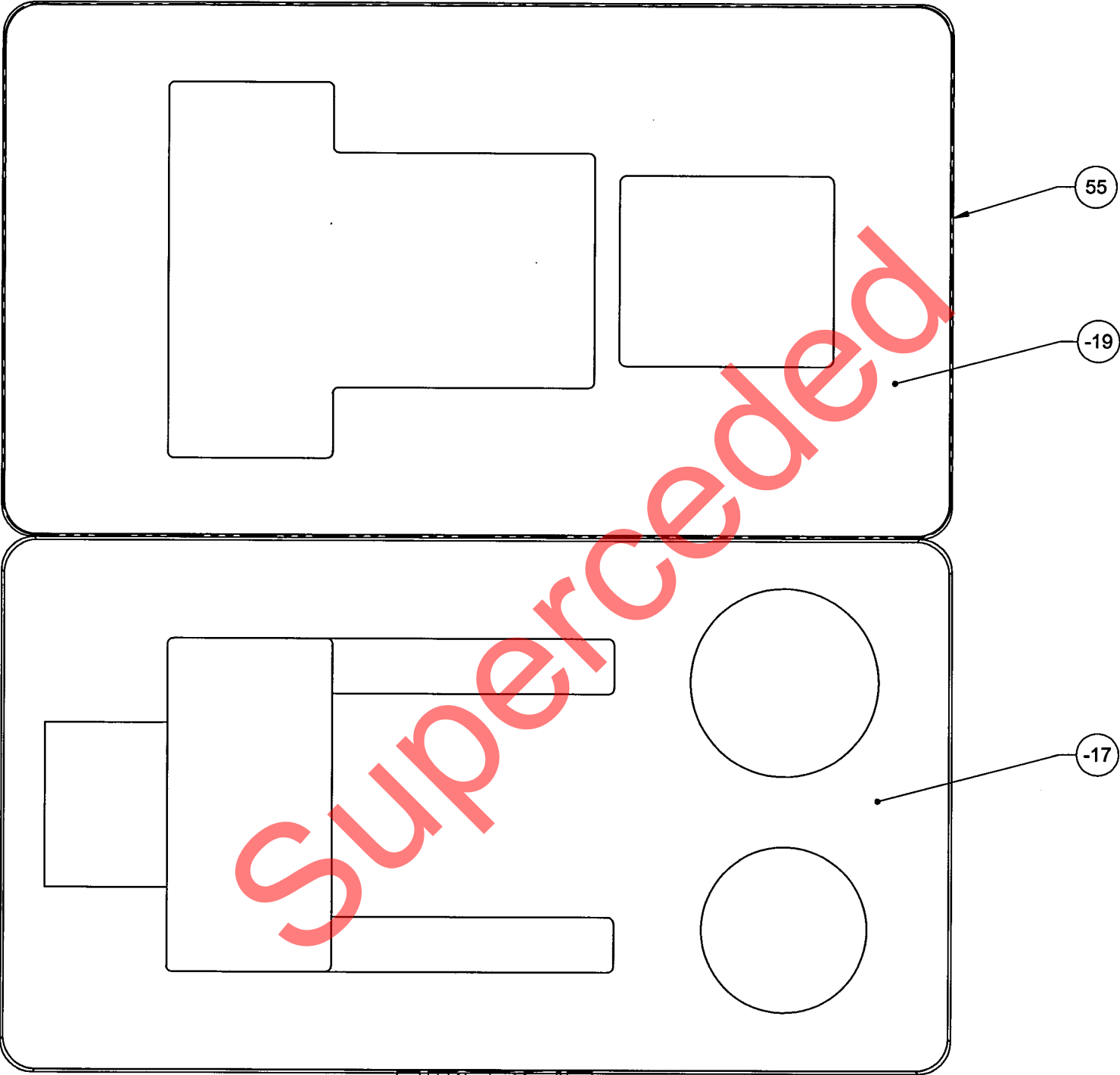
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM -43 WITH ITEM -45 AND REMOVE EXCESS
 - 10) DRILL HOLE AS SHOWN THEN APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 54 WITH ITEMS -43 AND -45 AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBEM652V3002101-M	SHEET 12 OF 17
APPROVED	VM	TITLE	SCALE
DATE 9/25/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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ITEM #	QTY	PART #	PART TITLE
-17	1	RBEM652V3002101-M-17	BOTTOM FOAM
-19	1	RBEM652V3002101-M-19	TOP FOAM
55	1	PELICAN #APP-1510-E	PELICAN CASE 1510



RBEM652V3002101-M-37 PACKAGING ASSY

UNDER REVIEW
URF 19-560 19.02.05 (PK)

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBEM652V3002101-M	SHEET 15 OF 17
APPROVED	VM	TITLE	SCALE
DATE 9/25/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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